

Shp Wed- AOG!

131219

Item ID:	D2749-1	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Fwd Strut 206B Basket 9.45				Stop	*NS2*
Start Date:	3/30/15	Start Qty: 1.00	*1*	Cust Item ID:		
Required Date:	4/01/15	Req'd Qty: 1.00	*1*	Customer:		
Reference:						

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

[illegible]

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 Required Date: 4/01/15 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				1	0		DFC 2015-3-31
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				1	0	15-3-31	DGL
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC5- Inspect part completeness to step on W/O	0.00				1			DAG 38 9-89
150									
QC	Memo	0.00							
Quality Control									

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 129 808</i> Memo START TIME: <u>3:20</u> FINISH TIME: _____ OVEN TEMPERATURE: _____	0.00 0.00				<u>1</u>	<u>0</u>	<u>15-3-31</u>	<u>338</u>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>①</u>			DAS 38 9-89
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>Ship</i> Memo	0.00 0.00				<u>1</u>			DAS 66 9-89 MAR 31 2015

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MCJ 15-03-31

W150331

Picklist Print

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Parent Item: D2749-1

D2749-1

Parent Item Name: Fwd Strut 206B Basket 9.45

Start Date: 3/30/15

Required Date: 4/01/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: C00.05.19Added inspect level 8, removed P/O for powder coatingEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X00.75 0		Purchased	No				f	3.1300		0.8			

M6061T6B0 750X00 750

6061-T6 Bar .750 x .750

**** J.C.L.**

Location

Loc Qty

Loc Code

MAT002

3.13

m130527

3.13

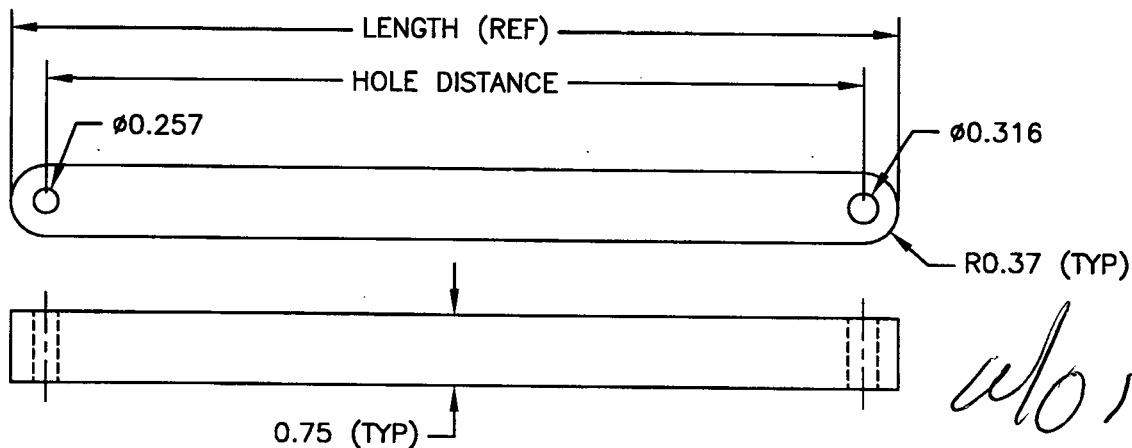
0.802 15/02/15

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2749	REV. C SHEET 1 OF 1
DATE 07.02.13		TITLE STRUT	SCALE NTS
A	99.09.24	NEW ISSUE	
B	99.10.08	REMOVED LIGHTENING HOLES	
C	07.02.13	ADD D2749-9/-11	

RELEASED

07.02.14



DART P/N	HOLE DISTANCE	LENGTH (REF)
D2749-1	8.700	9.45
D2749-3	7.890	8.64
D2749-5	12.630	13.38
D2749-7	10.340	11.09
D2749-9	7.000	7.75
D2749-11	5.188	5.94

D2749-1/-3/-5/-7/-9/-11 STRUT**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART MATERIAL SPEC M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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